

Work Order ID 129133

Wednesday, January 28, 2015 1:27:58 PM

129133

Ship Feb 20

Page 1

Item ID: D4820-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fpc Clip Assembly
 Start Date: 1/28/2015 Start Qty: 100.00 ***100*** Cust Item ID:
 Required Date: 1/28/2015 Req'd Qty: 100.00 ***100*** Customer:
 Reference:

Approvals: Process Plan: MJS Date: 1-28-28 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4820	A								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							110X 15/02/10 DAS 36 9-89
Packaging									
110		0.00							
110									
Small Fab	Memo	0.00							110X 15/02/10 DAS 36 9-89
Small Fab	Assemble as per dwg and grind rivet flush as shown								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							110 DAL 38 9-89
Quality Control									

FEB 17 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>STB</u>	0.00							
130						110			DAS
Packaging	Memo	0.00						FEB 18 2015	96
Packaging									9-89
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

Handwritten: 15/2/18 *[Signature]*
Handwritten: 152-18

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Picklist Print

Wednesday, January 28, 2015 1:28:01 PM

Page 1

Work Order ID: 129133

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Parent Item: D4820-041

D4820-041

Parent Item Name: Fpc Clip Assembly

Start Date: 1/28/2015

Required Date: 1/28/2015

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP REV:A NEW ISSUE 13-04-15 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4820-1 *D4820-1* Fpc Clip Base		Manufactured	No				Each	52.0000		100		15/02/10	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				GA				52					
				121573				52					
D4820-3 *D4820-3* Fpc Clip Profile		Manufactured	No				Each	0.0000		100		15/02/10	DAS 36 9-89
MS20426AD4-4 *MS20426AD4-4* Rivet		Purchased	No				Each	1,429.000		100		15/02/10	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				GA				339					
				125445				339					
				ST312				1090					
				125445				1090					

B 129134 (110x)

B 129135 (110x)

110

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

Work Order update only ☐

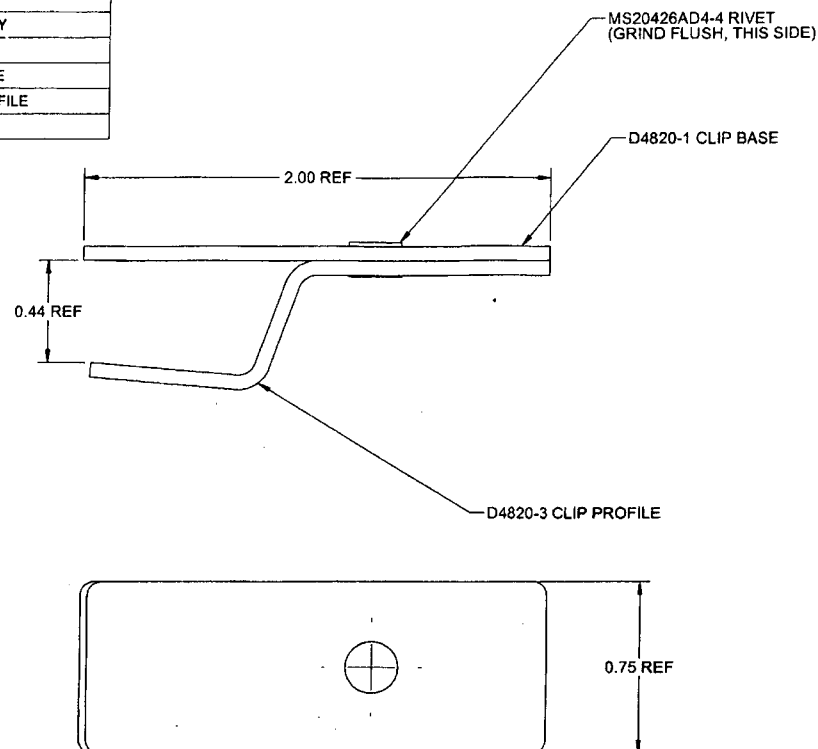
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D4820-041	CLIP ASSY
1	1	D4820-1	CLIP BASE
2	1	D4820-3	CLIP PROFILE
3	1	MS20426AD4-4	RIVET



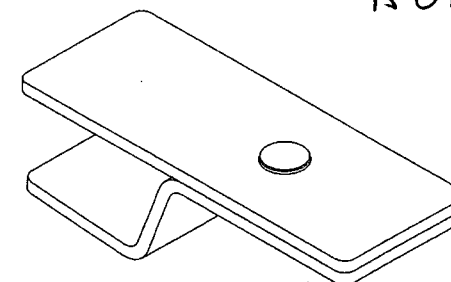
D4820-041 CLIP ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4820-041" USING FINE POINT PERMANENT MARKER, QSI 044, METHOD 6.1
- 7) WEIGHT: 0.06 lbs

SHOP
P

129.133 MLS
150128



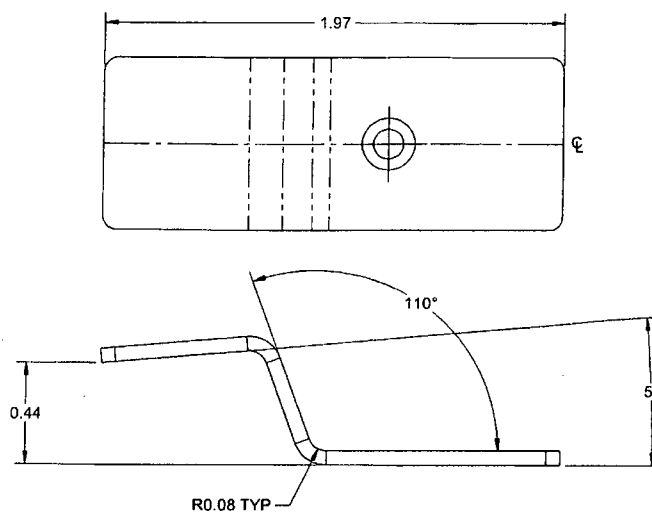
RELEASED
2013-04-18
mp

A	NEW ISSUE	DB	13.04.10
REV.	DESCRIPTION	BY	DATE
DESIGN	DB		
DRAWN	DB		
CHECKED	AP		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.04.10		

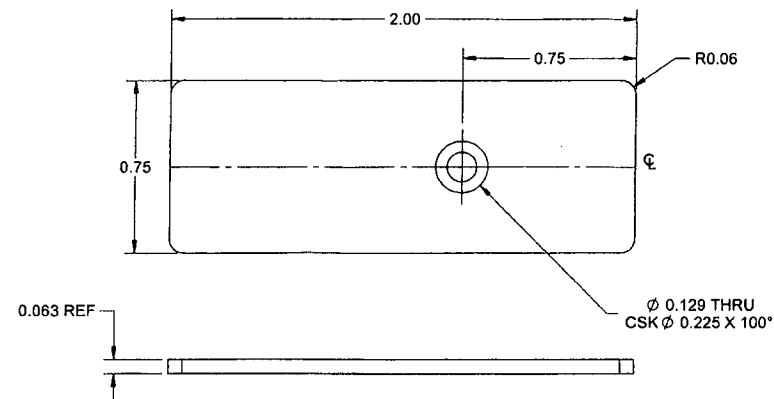
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4820** REV. A
SHEET 1 OF 2
TITLE **CLIP ASSY** SCALE NTS

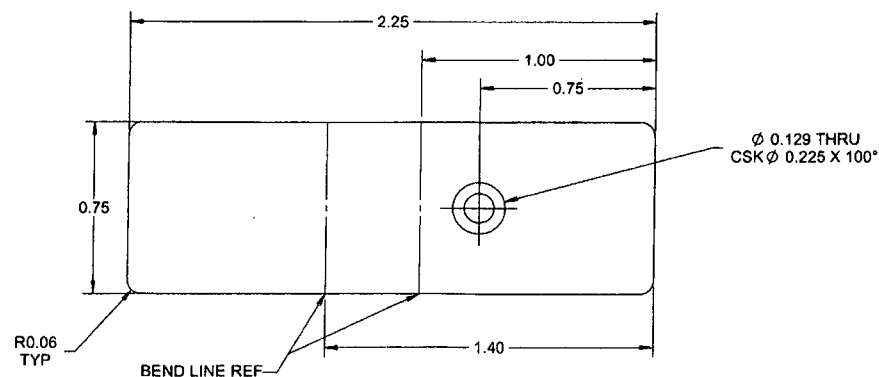
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D4820-3 CLIP PROFILE
(MAKE FROM D4820-3F)



D4820-1 CLIP BASE



D4820-3F FLAT PATTERN

RELEASED
2013-04-18

NOTES:

- 1) MATERIAL: AISI 304/316 SS, 0.063" THICK AS PER DART SPEC M304S16GA1P OR MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4820-1: 0.03 lbs, D4820-3: 0.03lbs

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.		D4820	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CLIP ASSY	NTS
DATE	13.04.10	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	